

Date: Thursday, 4/12/2007 8:45:07 AM  
User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: SADDLE FITTING, FWD (OUTBOARD/INBOARD)		
Job Number	: 31720		Part Number	: D2572		
Estimate Number	: 10531		Drawing Number	: D2572 REV E		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 4/12/2007	S.O. No.	: N/A		Drawing Revision	: E
Prsht Rev.	: NC		Type	: MACHINED PARTS		
First Issue	: N/A		Material	: N/A		
Previous Run	: 31714		Due Date	: 4/30/2007		
Written By			Qty:	16	Um:	Each
Checked & Approved By						
Comment	: Est: 1 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572 KJ					

## Additional Product

Job Number:

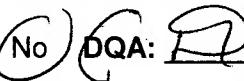


Seq. #:	Machine Or Operation:	Description :	
1.0	D6101005	7075-T7351 8.25X5.0X2.5	
Comment: Qty.: 1.0000 Each(s)/Unit Total : 16.0000 Each(s) 7075-T7351 8.25X5.0X2.5 Make from D6101-005 billet for D2572 Ensure that grain is along 5.00" length Batch No: _____			
<i>B25352 X9 B25350 X7</i> En 07/05/15			
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
Comment: HAAS CNC VERTICAL MACHINING #1 Program Batch No. <u>B31700</u> Double check by: <u>JL</u>			
1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets 4-Deburr and remove all machining marks 5-Tumble to remove sharp edges.			

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE	
Comment: CONVENTIONAL MILLING MACHINE Machine keyway as per dwg D2571 & D2572			

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
Comment: INSPECT PARTS AS THEY COME OFF MACHINE			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 07/05/09  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 4/12/2007 8:45:07 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, FWD (OUTBOARD/INBOARD)

Job Number: 31720

Part Number: D2572

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8

SECOND CHECK



Comment: SECOND CHECK

5.1 07/05/23

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



(16x)

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

m-h

07/05/24

7.0 POWDER COATING

POWDER COATING



11103141

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

41

07.05.25 (16)

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



7/5/28 5d

10

Comment: INSPECT POWDER COAT

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST432

7/5/28

5d

16

(16)

10.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/05/29

Job Completion



10 07.05.29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	31720
Description: Saddle, Fwd Inboard	Part Number:	D2572
Inspection Dwg: D2572 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

				Recorded Actual Dimensions						
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date	
A	0.438	0.443	DT8682	0.440	0.440	0.440	0.440			
B	1.745	1.755		1.747	1.750	1.750	1.750			
C	3.495	3.505		3.495	3.500	3.500	3.500			
D	1.745	1.755		1.747	1.750	1.750	1.749			
E	7.990	8.010		7.994	7.997	7.998	8.000			
F	0.490	0.510		0.494	.497	.495	.496			
G	0.257	0.262	DT8683	0.260	0.260	0.266	0.260			
H	0.375	0.380	DT8684	0.377	0.377	0.377	0.377			
I	0.490	0.510		0.493	.498	.499	.500			
J	1.174	1.184		1.175	1.178	1.179	1.179			
K	0.558	0.578		0.564	.565	.565	.564			
L	1.174	1.184		1.175	1.178	1.179	1.179			
M	1.490	1.500		1.492	1.498	1.499	1.499			
N	2.495	2.505		2.498	2.500	2.500	2.500			
O	3.869	3.879		3.873	3.874	3.874	3.874			
P	0.115	0.135		0.126	.128	.129	.128			
Q	0.115	0.135		0.135	0.135	0.135	0.135			
R	0.240	0.260		0.251	.253	.252	.251			
S	0.115	0.135		0.121	.125	.125	.125			
T	0.178	0.198		0.188	0.188	0.188	0.188			
U	2.940	2.980		2.966	2.960	2.960	2.960			
V	0.230	0.250		0.240	.240	.240	.240			
W	0.115	0.135		0.126	.128	.129	.128			
X	0.307	0.312		0.311	.312	.312	.312			
Y	0.760	0.765		0.765	0.765	0.765	0.765			
Z	0.352	0.372		0.362	.363	.362	.362			
AA	0.470	0.530		0.500	0.500	0.500	0.500			
AB	0.615	0.635		0.626	.628	.629	.628			
AC	0.053	0.073		0.063	0.063	0.063	0.063			
AD	0.240	0.260		0.248	.250	.247	.249			
AE	1.375	1.395		1.385	1.387	1.387	1.387			
AF	0.115	0.135		0.135	0.135	0.135	0.135			
AG	0.240	0.280		0.260	0.260	0.260	0.260			
AH	0.240	0.260		0.251	.250	.250	.250			
AI	2.000	2.020		2.000	2.000	2.000	2.000			
AJ	0.023	0.043		0.033	0.033	0.033	0.033			
Accept/Reject										

Measured by:	En /M8
Date:	07/05/17

Audited by:	J.L
Date:	07/05/17

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	JL

DART AEROSPACE LTD	Work Order:	31720
Description: Saddle, Fwd Inboard	Part Number:	D2572
Inspection Dwg: D2572 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443	DT8682	.440	.440	0.440	0.440		
B	1.745	1.755		1.747	1.750	1.745	1.750		
C	3.495	3.505		3.500	3.500	3.499	3.499		
D	1.745	1.755		1.751	1.750	1.745	1.750		
E	7.990	8.010		8.001	8.001	8.001	8.001		
F	0.490	0.510		.500	.500	0.496	0.496		
G	0.257	0.262	DT8683	.258	.259	0.260	0.260		
H	0.375	0.380	DT8684	.376	.376	0.377	0.377		
I	0.490	0.510		.500	.500	0.495	0.494		
J	1.174	1.184		1.179	1.178	1.174	1.176		
K	0.558	0.578		.567	.568	0.563	0.567		
L	1.174	1.184		1.178	1.179	1.174	1.176		
M	1.490	1.500		1.496	1.496	1.494	1.492		
N	2.495	2.505		2.500	2.500	2.498	2.499		
O	3.869	3.879		3.873	3.874	3.874	3.876		
P	0.115	0.135		.128	.128	0.127	0.127		
Q	0.115	0.135		.125	.125	0.135	0.135		
R	0.240	0.260		.250	.250	0.253	0.252		
S	0.115	0.135		.128	.127	0.122	0.120		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.961	2.960	2.960	2.960		
V	0.230	0.250		.242	.240	0.240	0.235		
W	0.115	0.135		.125	.125	0.127	0.122		
X	0.307	0.312		.310	.310	0.311	0.311		
Y	0.760	0.765		.762	.762	0.765	0.765		
Z	0.352	0.372		.365	.365	0.365	0.365		
AA	0.470	0.530		.500	.500	0.500	0.500		
AB	0.615	0.635		.622	.625	0.625	0.625		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.252	.250	0.244	0.245		
AE	1.375	1.395		1.385	1.384	1.384	1.382		
AF	0.115	0.135		.125	.125	0.135	0.135		
AG	0.240	0.280		.262	.260	0.260	0.260		
AH	0.240	0.260		.250	.250	0.250	0.245		
AI	2.000	2.020		2.001	2.000	2.000	2.000		
AJ	0.023	0.043		.032	.032	.032	.032		
Accept/Reject									

Measured by:	MS /	EP	Audited by:	SK
Date:	01/05/18	07/05/19	Date:	07.05.21

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	JKL

DART AEROSPACE LTD	Work Order:	31720
Description: Saddle, Fwd Inboard	Part Number:	D2572
Inspection Dwg: D2572 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	0.440	0.440	0.440	0.440		
B	1.745	1.755		1.750	1.747	1.748	1.748		
C	3.495	3.505		3.499	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.747	1.749	1.749		
E	7.990	8.010		8.001	8.001	8.002	8.002		
F	0.490	0.510		0.501	0.498	0.497	0.496		
G	0.257	0.262	DT8683	0.266	0.260	0.260	0.260		
H	0.375	0.380	DT8684	0.377	0.377	0.379	0.377		
I	0.490	0.510		0.498	0.498	0.496	0.495		
J	1.174	1.184		1.174	1.175	1.174	1.178		
K	0.558	0.578		0.567	0.565	0.567	0.564		
L	1.174	1.184		1.174	1.175	1.174	1.178		
M	1.490	1.500		1.494	1.496	1.494	1.492		
N	2.495	2.505		2.498	2.497	2.496	2.497		
O	3.869	3.879		3.873	3.872	3.870	3.874		
P	0.115	0.135		0.127	0.127	0.126	0.126		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.253	0.252	0.251	0.251		
S	0.115	0.135		0.124	0.124	0.124	0.124		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		0.239	0.239	0.240	0.241		
W	0.115	0.135		0.121	0.121	0.125	0.124		
X	0.307	0.312		0.311	0.311	0.311	0.311		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.365	0.365	0.365	0.365		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.626	0.626	0.630	0.624		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.246	0.247	0.246	0.249		
AE	1.375	1.395		1.387	1.381	1.386	1.386		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.249	0.248	0.248	0.248		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by:	SN	Audited by:	SA
Date:	07.05.20	Date:	07.05.21

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	SA

DART AEROSPACE LTD	Work Order:	31720
Description: Saddle, Fwd Inboard	Part Number:	D2572
Inspection Dwg: D2572 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

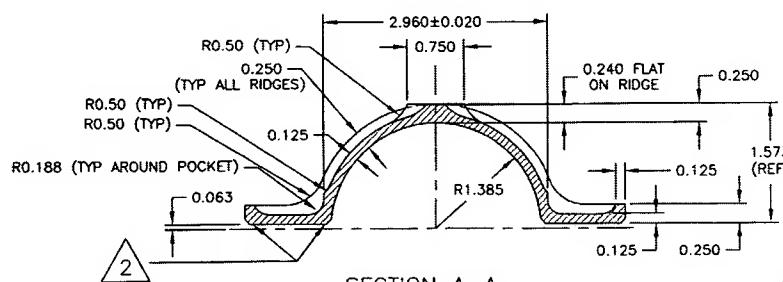
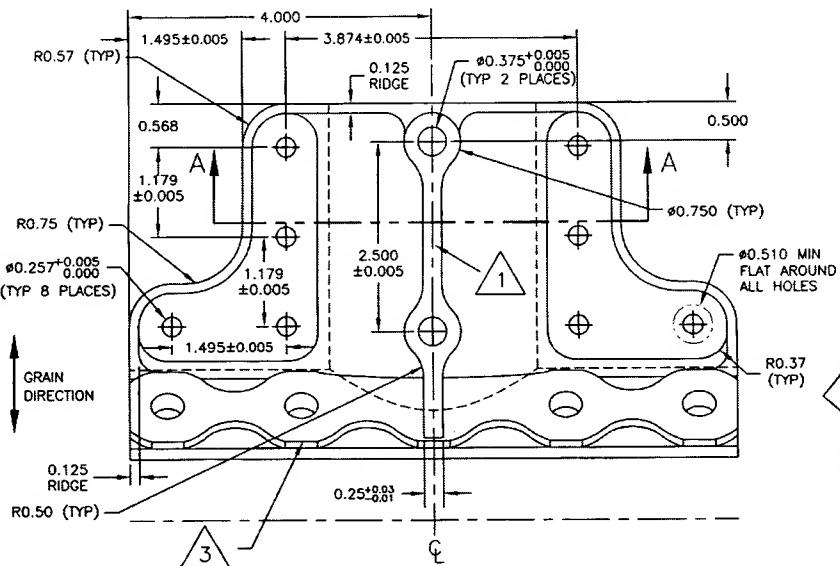
			Recorded Actual Dimensions						
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	0.440	0.440	0.440	0.440		
B	1.745	1.755		1.746	1.748	1.748	1.750		
C	3.495	3.505		3.498	3.500	3.500	3.500		
D	1.745	1.755		1.746	1.749	1.750	1.750		
E	7.990	8.010		8.002	8.000	8.002	8.001		
F	0.490	0.510		0.500	.501	.501	.500		
G	0.257	0.262	DT8683	0.260	0.260	0.260	0.260		
H	0.375	0.380	DT8684	0.377	0.377	0.377	0.377		
I	0.490	0.510		0.496	.496	.497	.497		
J	1.174	1.184		1.175	1.179	1.179	1.179		
K	0.558	0.578		0.565	.565	.565	.565		
L	1.174	1.184		1.175	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.496	2.499	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		0.125	.128	.128	.127		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.250	.250	.253	.250		
S	0.115	0.135		0.124	.125	.128	.128		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		0.236	.238	.240	.240		
W	0.115	0.135		0.128	.127	.125	.127		
X	0.307	0.312		0.312	.312	.312	.312		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.362	.363	.362	.362		
AA	0.470	0.530		0.560	0.560	0.560	0.560		
AB	0.615	0.635		0.628	.625	.625	.625		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.245	.247	.245	.244		
AE	1.375	1.395		1.386	1.386	1.388	1.388		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.247	.248	.247	.247		
AI	2.000	2.020		2.006	2.000	2.000	2.000		
AJ	0.023	0.043		0.033	0.033	0.032	0.033		
Accept/Reject									

Measured by:	En/M8
Date:	07/05/23

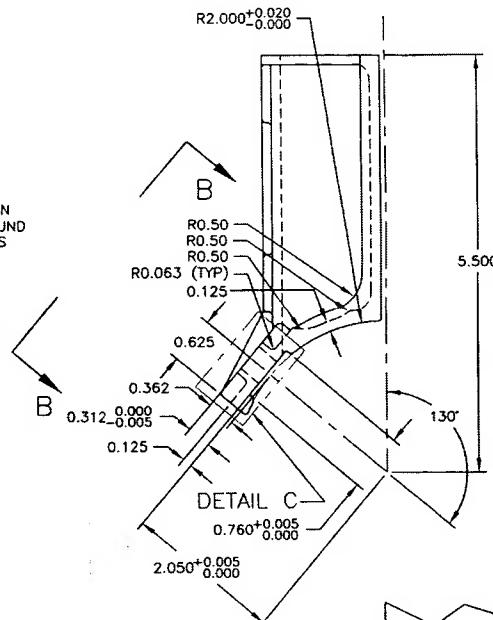
Audited by:	J-L
Date:	07/05/23

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

RELEASED  
05.12.06



SECTION A-A



DETAIL C  
SCALE 2:1

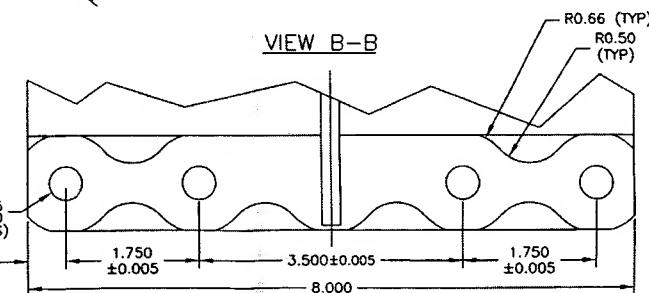
0.438±0.005  
(TYP 4 PLACES)

0.500

1.750±0.005

3.500±0.005

1.750±0.005



### NOTES

MATERIAL: 7075-T7351 (QQ-A-250/12)  
(REF DART SPEC. D6102-003)  
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER  
DART QSI 005 4.3  
BREAK ALL SHARP EDGES 0.010 TO 0.020  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 2 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 3 CHAMFER 0.063 x 45° ALL AROUND
- 4 CHAMFER 0.033 x 45° (SEE DETAIL C) E

VIEW B-B

E	05.07.13	ADD CHAMFER ON RIDGE NOTE 4
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE
DESIGN	DRAWN BY	DART AEROSPACE LTD. HAWKSBURY, ONTARIO, CANADA
DS	PH	
CHECKED	APPROVED	DRAWING NO.
		D2572
DATE		REV. E
05.07.13		SHEET 1 OF 1
		TITLE
		INNER FWD SADDLE
		SCALE
		2:1

SHOP COPY  
RETURN TO  
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UNCONTROLLED COPY  
WITHOUT NOTICE  
WORK ORDER NO. 31720

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